



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

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15329 D5149-7TRN
Job Sheet 193260



Part No: D5149-7TRN

Job Qty: 10 pcs

Part Name: Aft Step Base Turning Detail



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 4/9/19

Job Tracking No: 15329

Due Date: 6/20/19

Created By: Dara Macdonald

Type: SOLD

Description:

Note: DWG REV D SHEET 10 IPP REV:A NEW ISSUE 14-12-08 JLM VERIFIED BY:DD

Ship Via:

5 7/16 each blank

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
100	Doosan - 1	10 pcs	6/20/19	6/20/19	0.00	0.00	Doosan - 1		DAS 5 9-89
110	QC 2	10 pcs	6/20/19	6/20/19	0.00	0.00	QC 2 - 1		5 9-89
							QC 2 - 12		
							QC 2 - 14		
							QC 2 - 17		
							QC 2 - 19		
							QC 2 - 2		
							QC 2 - 20		
							QC 2 - 22		DAS 5 9-89
							QC 2 - 23		
							QC 2 - 25		
							QC 2 - 32		
							QC 2 - 33		
							QC 2 - 35		
							QC 2 - 39		
							QC 2 - 4		
							QC 2 - 40		
							QC 2 - 44		
							QC 2 - 45		
							QC 2 - 48		
							QC 2 - 49		
							QC 2 - 50		
							QC 2 - 51		
							QC 2 - 52		
							QC 2 - 57		
							QC 2 - 62		
							QC 2 - 63		
							QC 2 - 8		
							QC 2 - 66		
							QC 2 - 64		

begin at 7h40AM
19/5/12
plex on maintenance

QC 2 5 9-89



Container No: S180413



Part: D5149-7TRN

Job No: 193260

Serial No/Batch: S180413

Revision:

Inspector:

Exp Date:

Instructions:

Dart Aerospace Ltd.
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CANADA
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Date: 05/12/19

				QC 2 - 65	
				QC 2 - 5	
				QC 2 - 71	
120 QC 8	10 pcs	6/20/19	0.00 0.00	QC 8 - 12	
				QC 8 - 14	
				QC 8 - 17	
				QC 8 - 20	
				QC 8 - 25	
				QC 8 - 3	
				QC 8 - 32	
				QC 8 - 33	
				QC 8 - 35	
				QC 8 - 39	
				QC 8 - 4	
				QC 8 - 44	
				QC 8 - 45	
				QC 8 - 49	
				QC 8 - 58	
				QC 8 - 8	
				QC 8 - 9	
				QC 8 - 68	
				QC 8 - 67	
				QC 8 - 1 (A)	
				QC 8 - 47	
				QC 8 - 40	
				QC 8 - 52	
				QC 8 - 23	
130 Packaging 3-1 - Stock - B4B	10 pcs	6/20/19	0.00 0.00	Packaging 3 - 1 - B4B	
				Packaging 3 - 2 - B4B	
				Packaging 3 - 3 - B4B	
				Packaging 3 - 4 - B4B	
				Packaging 3 - 5 - B4B	
				Packaging 3 - 6 - B4B	
				Packaging 3 - 7 - B4B	
				Packaging 3 - 8 - B4B	
				Packaging 3 - 9 - B4B	
				Packaging 3 - 10 - B4B	
				Packaging 3 - 11 - B4B	
				Packaging 3 - 12 - B4B	
				Packaging 3 - 13 - B4B	
				Packaging 3 - 14 - B4B	
				Packaging 3 - 15 - B4B	
				Packaging 3 - 16 - B4B	
				Packaging 3 - 17 - B4B	
				Packaging 3 - 18 - B4B	
				Packaging 3 - 19 - B4B	
				Packaging 3 - 20 - B4B	
				Packaging 3 - 21 - B4B	
				Packaging 3 - 22 - B4B	
				Packaging 3 - 23 - B4B	
				Packaging 3 - 24 - B4B	
				Packaging 3 - 25 - B4B	
				Packaging 3 - 26 - B4B	
				Packaging 3 - 27 - B4B	
				Packaging 3 - 28 - B4B	
				Packaging 3 - 29 - B4B	
				Packaging 3 - 30 - B4B	
				Packaging 3 - 31 - B4B	
				Packaging 3 - 32 - B4B	

07/19/08/13

				Packaging 3 - 33 - B4B	
				Packaging 3 - 34 - B4B	
				Packaging 3 - 35 - B4B	
				Packaging 3 - 36 - B4B	
140 QC 21 - SA	10 pcs	6/20/19	0.00 0.00	QC 21 - SA - 21	
				QC 21 - SA - 70	
				QC 21 - SA - 53	

Part Op 100 - Doosan Lathe - Turn blank as per Folio FB356
 Descriptions: 110 - QC2- Inspect parts off machine FAI/FAIB
 120 - QC8- Inspect parts - second check
 130 - Identify as per dwg & Stock Location: _____ LOCATION: MAT060
 140 - QC21- Final Inspection - Work Order Release

2019
21
9-03

MAY 14 2019

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
M6061T6R3.250	6061-T6 Round Bar 3.250"	4.1600 ft (.416 ea)	100-Doosan - 1	5172243

MAT
used
4.250
7422

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
100-Doosan - 1	M6061T6R3.250	4	0	0

Part Specifications

Spec No	Description	Target/Tolerance	Limits	Type	Special Comments
1	Aft Step Base	3.232Inches + 0.012 - 0.001	3.244 3.231	3.231	
2	Aft Step Base	2.875Inches + 0.012 - 0.001	2.887 2.874	2.881	
3	Aft Step Base	0.032Inches ± 0.010	0.042 0.022	R 1/32	Radius
4	Aft Step Base	0.060Inches ± 0.010	0.070 0.050	0.061	
5	Aft Step Base	0.060Inches ± 0.030	0.090 0.030	0.061	
6	Aft Step Base	0.875Inches ± 0.010	0.885 0.865	0.876	
7	Aft Step Base	3.190Inches ± 0.030	3.220 3.160	3.190	
8	Aft Step Base	4.000Inches ± 0.030	4.030 3.970	3.996	

Plex 4/9/19 4:11 PM Dart.Macdonald.Dara

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